

Work Order ID 57105

March 22, 2010 9:09:25 AM

PROTOTYPE
PROTOTYPESUE



Page 1

Item ID: D4059-042

Accept



Setup Start



Revision ID:

Stop



Item Name: Ski Section Assembly, Aft RH

Start Date: 3/22/10 Start Qty: 1.00



Cust Item ID:

Required Date: 3/23/10 Req'd Qty: 1.00



Customer:

Reference:

Approvals:

Process Plan:

[Signature]

Date:

Tooling:

Date:

Run Start



QC:

Date:

SPC (Y/N):

Date:

Stop



Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4059

PA1 Rev. A

[Signature]

100

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

Pick Kit

10/03/30 x1

110

0.00



HandThermo

Memo

0.00

Hand Finishing Thermoforming

1- Assemble as per Dwg D4059-042

2- Use wearplate to locate and to transfer drill holes in ski as per dwg and use 0.375" unibit to open wearplate mounting holes to finish size.

3- use wearbar to locate & transfer drill as per dwg. install wearbars.

10/03/30 x1

120

0.00



QC

Quality Control

Memo

QC6- Inspect dimensions to drawing

0.00

1

7/04/08

БЮЛОЛАБЕ
БЮЛОЛАБЕ

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Item ID: D4059-042

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Accept

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Stop

Cust Item ID:

Customer:

Approvals:

Process Plan:

Date:

Tooling:

Date:

Run

Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center IDOperation
DescriptionSet Up/
Run HoursDraw
NumberDraw
Rev.Plan
CodeAccept
QtyReject
QtyReject
NumberInsp.
Stamp

130

Identify as per dwg & Stock Location: _____

0.00



Packaging

Memo

0.00

Packaging

140

QC21- Final Inspection - Work Order Release

0.00



QC

Memo

0.00

Quality Control

10-4-12

10/04/12

POSITIVE RECALL
EFFECTIVE
DATE

10-4-12

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Work Order ID: 57105

Parent Item: D4059-042

Parent Item Name: Ski Section Assembly, Aft RH


Comments: New Issue 10/03/16 Rev. A DL verified by:DD

Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
AN4-6A  Bolt		Purchased	No			100	Each	1,239.000	10.0000			

Warehouse Location	Loc Qty	Loc Code
Main Warehouse		
ST356	1239	
442720	39	
112829	300	
112933	300	
113149	600	

D4059-2



Ski Section, RH

D4067-041






Joggled Wearplate

D4068-041



Curved Wearplate

Manufactured	No	100	Each	0.0000	1.0000
			Batch 57103		
Manufactured	No	100	Each	0.0000	2.0000
			56342		
Manufactured	No	100	Each	0.0000	1.0000
			56349		

10 OK 10/03/30.

x1 OK 10/03/30

x2 OK 10/03/30

x1 OK 10/03/30

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Work Order ID: 57105

Parent Item: D4059-042

Parent Item Name: Ski Section Assembly, Aft RH



Comments: New Issue 10/03/16 Rev. A DL verified by:DD

Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
MS21043-4  Nut		Purchased	No			100	Each	725.0000	10.0000			

<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
OFFSHORE		
FG	40	
104603	40	
Main Warehouse		
ST301	685	
112314	100	
112492	11	
113064	174	
114181	400	

NAS1149F0432P

Purchased

No



Washer

100 Each 403.0000 10.0000



<u>Warehouse</u> <u>Location</u>	<u>Loc Qty</u>	<u>Loc Code</u>
Main Warehouse		
ST275	403	
110098	200	
112940	100	
18057	103	

10 DL 10/03/30

10 DL 10/03/30

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Work Order ID: 57105

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Comments: New Issue 10/03/16 Rev. A DL verified by:DD

Start Date: 3/22/10

Required Date: 3/23/10

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
NAST149F0463P Washer		Purchased	No			100	Each	229.0000	10.0000			

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
ST275	229	
108246	29	
114223	200	

10 DL 10/03/30

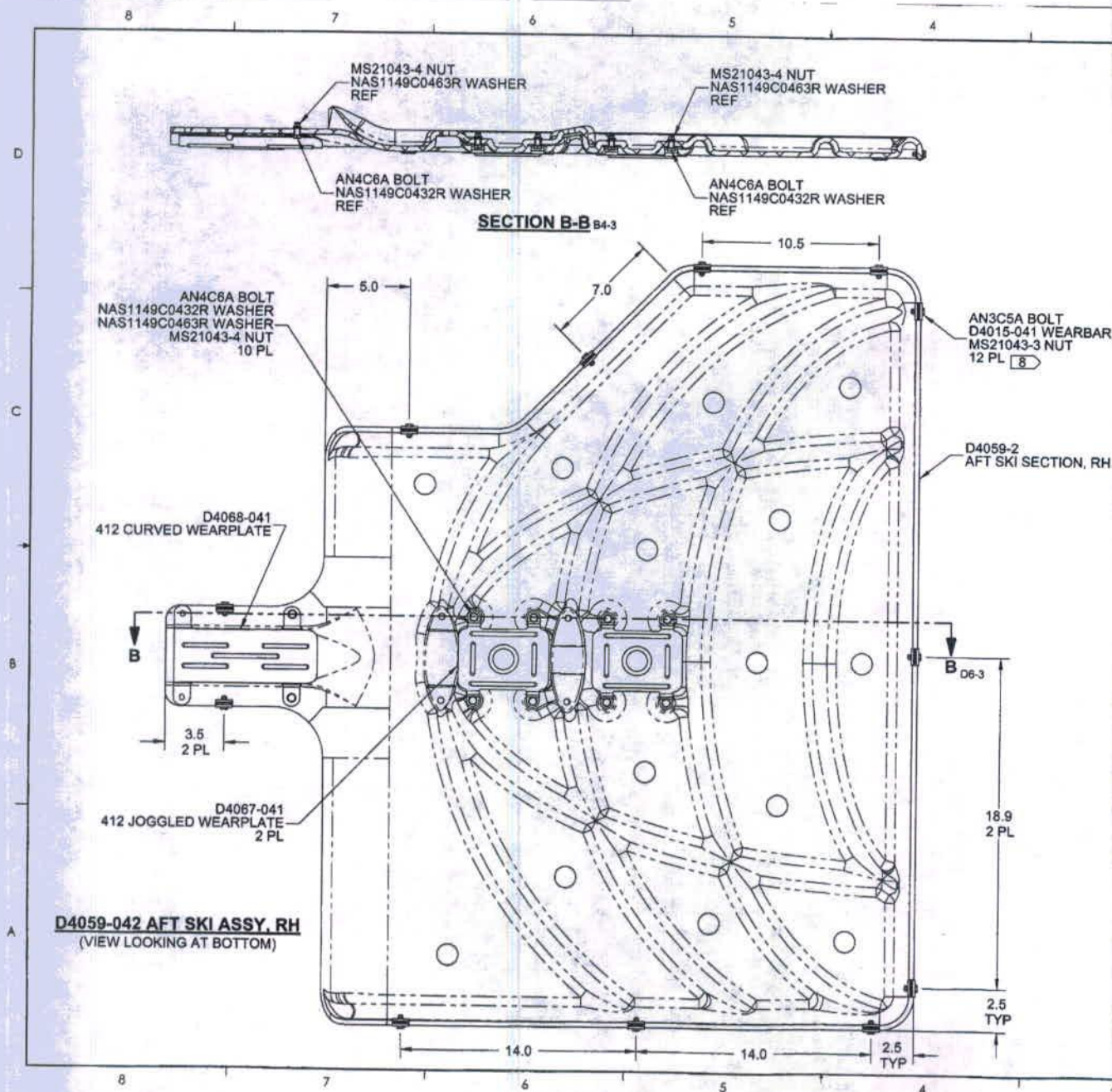
A03C5A BOLT
M521043-3 NUT
D4015-041 WEARBAR.

M114108 x (12) DL 10/03/31
M112314 x (12) DL 10/03/31
M53956 x (12) DL 10/03/31

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ITEM	QTY -041	P/N	DESCRIPTION
1	X	D4059-042	AFT SKI ASSY, RH
2	12	D4015-041	WEARBAR
3	1	D4059-2	AFT SKI SECTION, RH
4	2	D4067-041	412 JOGGLED WEARPLATE
5	1	D4068-041	412 CURVED WEARPLATE
6	12	AN3C5A	BOLT
7	12	MS21043-3	NUT
8	10	MS21043-4	NUT
9	10	AN4C6A	BOLT
10	10	NAS1149C0432R	WASHER
11	10	NAS1149C0463R	WASHER

D4059-042 NOTES:

- 1) MATERIAL: N/A
- 2) FINISH: N/A
- 3) TOLERANCES: PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) UNITS: INCHES UNLESS OTHERWISE NOTED
- 5) BREAK SHARP EDGES: 0.005 TO 0.010 MAX
- 6) IDENTIFICATION: NONE
- 7) WEIGHT: 26.0 lbs
- 8) LOCATE D4015-041 (ITEM 2) AS SHOWN.
TRANSFER DRILL $\varnothing 0.191$ HOLE FROM D4015-041 TO D4059-2.
CHAMFER HOLE 0.03 X 45°
FASTEN USING PRESCRIBED HARDWARE
- 9) TORQUE: AN3 NUTS = 15-20 in-lb
AN4 NUTS = 50-70 in-lb

DESIGN		DART AEROSPACE LTD	
DRAWN		HAWKESBURY, ONTARIO, CANADA	
CHECKED		DRAWING NO.	REV. A
MFG. APPR.		D4059	SHEET 3 OF 6
APPROVED		TITLE	SCALE
DE APPR.		AFT SKI ASSY	NTS
DATE	10.03.31	COPYRIGHT © 2010 BY DART AEROSPACE LTD. THIS DOCUMENT IS PRIVATE AND CONFIDENTIAL AND IS SUPPLIED ON THE EXPRESS UNDERSTANDING THAT IT IS NOT TO BE USED FOR ANY PURPOSES OR COPIED OR REPRODUCED IN ANY MANNER WITHOUT THE WRITTEN PERMISSION OF DART AEROSPACE LTD.	

W/O 57105

RELEASED
2010-04-07
W/P

